

43

Date: Tuesday, 10/2/2007 10:43:57 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER  
 Job Number : 34941C  
 Estimate Number : 10302  
 P.O. Number : N/A Part Number : D32391  
 This Issue : 10/2/2007 S.O. No. : N/A Drawing Number : D3239 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : 32816C Material : N/A  
 Due Date : 10/22/2007 Qty: 8 Um: Each  
 Written By :  
 Checked & Approved By : 10/2/2007  
 Comment : Est Rev: A New Issue 05-11-06 JLM  
 Est: b 06.11.15 waterjet EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.1890 sf(s)/Unit Total : 1.5120 sf(s)  
 Material: 6061-T6 (QQ-A-250/11) 0.050" thick  
 (M6061T6S0.050)  
 Identify for D3239-1  
 Batch: M103321 HB 07-10-4

PTO

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3239  
 Dwg Rev: A  
 Prog Rev: A HB 07-10-4

8

2-Deburr if necessary HB 07-10-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-10-4

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Gr 07/10/04 (x8)

Covers

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary. HB 07-10-4

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3239H PAR #: N/A Fault Category: Prod / FAB. ASS' <sup>med & small</sup> NCR: Yes / No DQA: Yes / No Date: 07/10/12  
 QA: N/C Closed: Yes / No Date: 07.10.12

NCR: <u>34941 C</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.04	1.0	2024-T3 USED INSTEAD OF 6061-T6 R.C. Hummer error. Pulled mat. with no mat. Description on it	LE 07.10.04 PS1042	ACCEPTABLE. NOT DETRIMENTAL TO PERFORMANCE	LE 07.10.04	<u>Yes</u> 07/10/04	LE 07.10.04 PS1042	<u>Yes</u> 07/10/04

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 34941C

Part Number: D32391

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 11 07-10-11 (8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 7/10/11 59 (8X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Handwritten: 7/10/11 50 (8V)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 207/10/12 (8)

Job Completion



Handwritten: 11 07-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

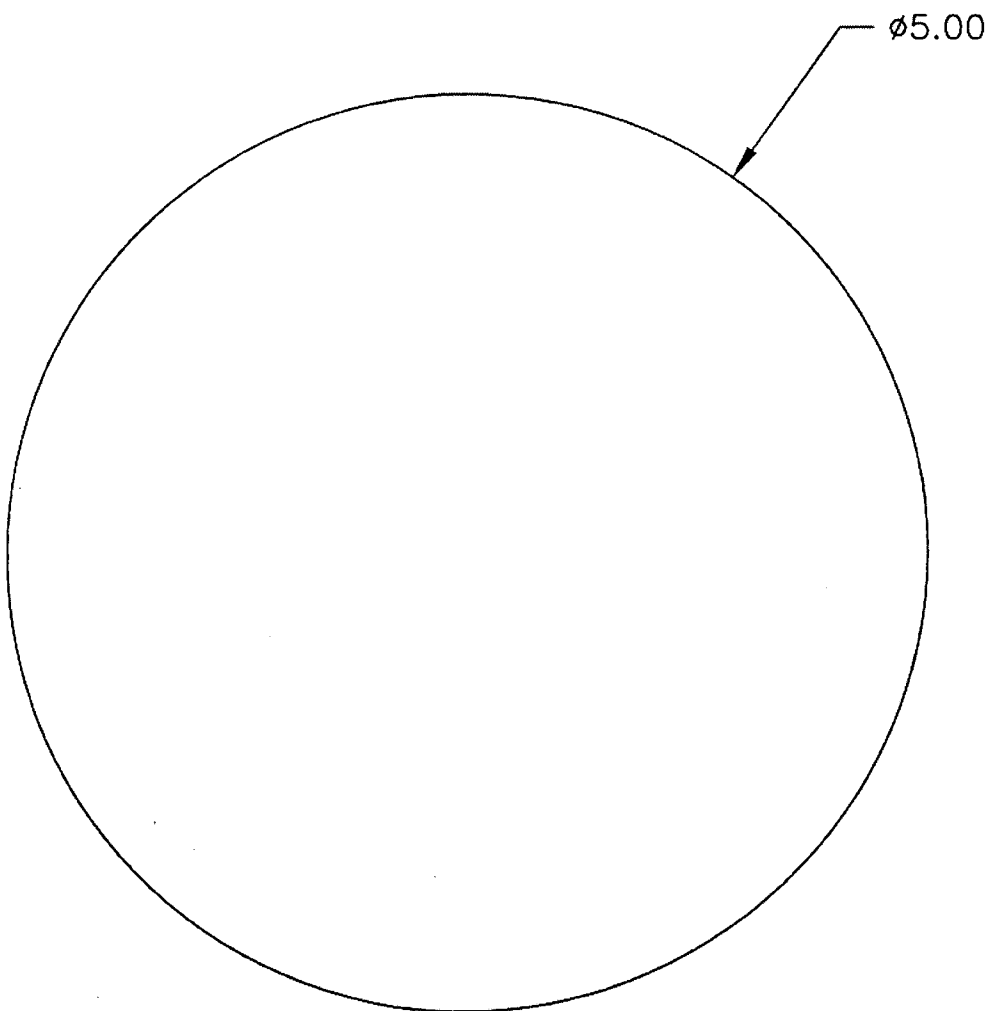
**NOTE:** Date & initial all entries





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3239	REV. A SHEET 1 OF 1
DATE 03.12.19		TITLE COVER	SCALE 1:1
A	03.12.19	NEW ISSUE	

**RELEASED**  
04.02.03



**D3239-1 COVER**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.050 THICK (REF. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

SHOP COPY  
RETURN TO  
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WITHOUT NOTICE  
WORK ORDER

NO. 34941c

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